

Date: Thursday, 2/22/2007 2:58:45 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FITTING
Job Number	: 30834		
Estimate Number	: 10438		
P.O. Number	: <i>N/A</i>	Part Number	: D32991
This Issue	: 2/22/2007	Drawing Number	: D3299 REV <i>AB</i>
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i>	Drawing Revision	: <i>AB</i>
Previous Run	: <i>N/A</i>	Material	: <i>N/A</i>
Written By	:	Due Date	: 3/20/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	6 Um: Each
Comment	: Est: A 04.10.04 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M6061T6H1625	6061T6 hex bar 1.625
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Comment: Qty.: 0.2013 f(s)/Unit Total: 1.2077 f(s)

6061T6 hex bar 1.625

Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 1.625" Hex

(M6061T6H1.625)

Identify as D3299-1

Batch: *M17625**DSP 07/06/04**(12)*

2.0	HARDINGE <i>Band saw</i>	HARDINGE CNC LATHE SMALL
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Comment: ~~HARDINGE CNC LATHE SMALL~~ *Band saw*

Cut blank: 2.200" long

Turn as per Folio FA451 and Dwg D3299

DSP 07/06/04

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	BAND SAW <i>band saw</i>	BAND SAW
-----	-------------------------------------	----------



Comment: ~~BAND SAW~~ *band saw*

Machine as per Folio FA451 and Dwg D3299

Deburr

MS / DSP 07/06/04 (12)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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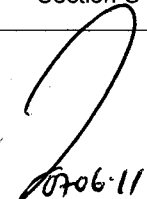
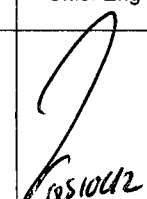
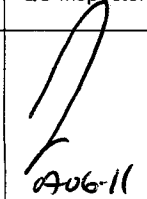


Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*MS / MS 07/06/04**11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/08	4.0	1 part scrap - Enrich 90° too deep 1-part scrap during turning thrusts no good.	 05/10/12	- raise tool offset 2 scrap no replace	SA 07/06/08	 07/06/11	 05/10/12	 07/06/11

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 2:58:45 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 30834

Part Number: D32991

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 07/06/11

7.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 3943

Anodize as per Dwg D3299

Possible Supplier: TNM Paint

Material release note is required

02/07/06/11 (10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

05/07/06/18 (10)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11 07-06-19 10

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SF 90

2/6/19 59 (10)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/19

Job Completion



11 07-06-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 30834
Description: Fitting		Part Number: D3299-1
Inspection Dwg: D3299	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+/-0.030	1.250	✓			
0.476	+0.000/-0.005	.4753	✓			
0.550	+/-0.010	.550	✓			
1.00	+/-0.030	.999	✓			
2.10	+/-0.030	2.107	✓			
0.773	+/-0.010	.776	✓			
0.10	+/-0.030	.10	✓			
0.20	+/-0.030	.20	✓			
0.550	+/-0.010	.550	✓			
MOW Max = 0.573 Min = 0.565	Max = 0.573	.571	✓			
Ø0.302	+0.005/-0.000	.302	✓			
Ø0.688	+0.005/-0.000	.688	✓			
Ø0.580	+0.005/-0.000	.582	✓			
53°	+/-0.5°	53°	✓			
1.09	+/-0.030	1.09	✓			

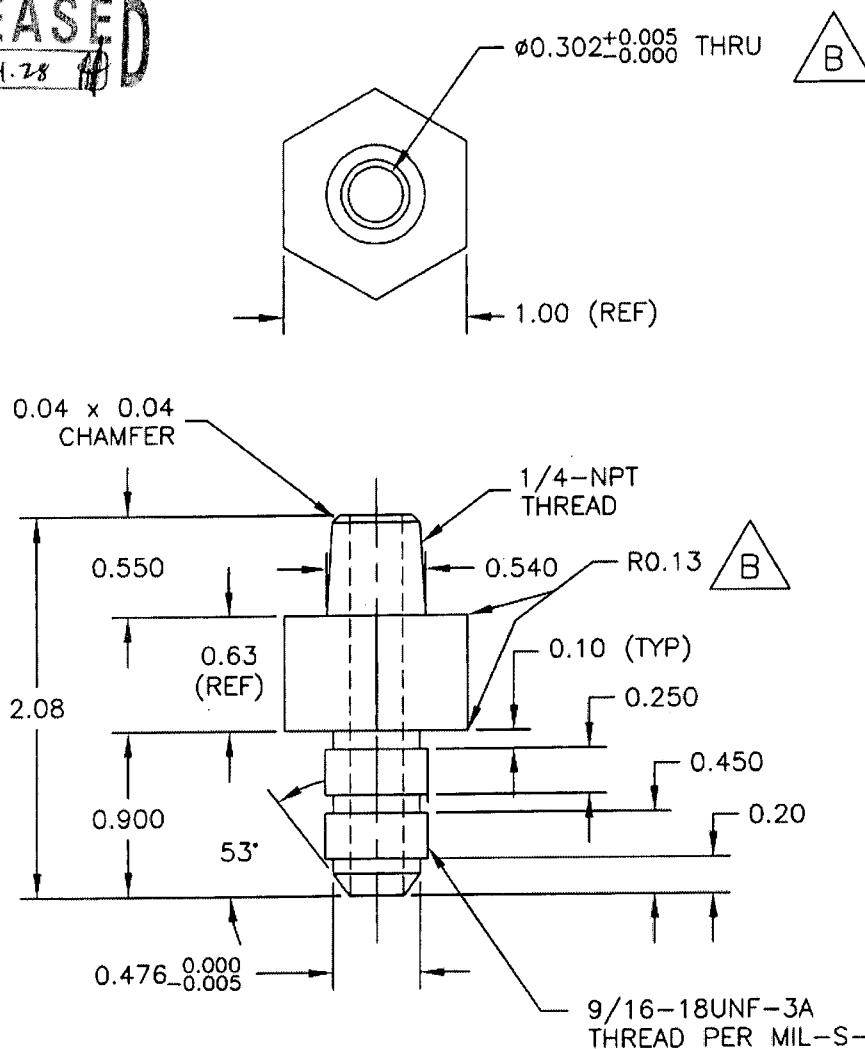
Measured by: M8136	Audited by: MK	Prototype Approval:	N/A
Date: 07/06/09	Date: 07/06/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.12	New Issue	KJ/JLM	
B	05.05.25	Ø0.302 was Ø0.312; 1.09 added	KJ/JLM	



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3299	REV. B SHEET 2 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:1

RELEASED
05.04.28



D3299-3

D3299-3 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.00 HEX BAR (M6061T6H1000)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS II
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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WORK ORDER

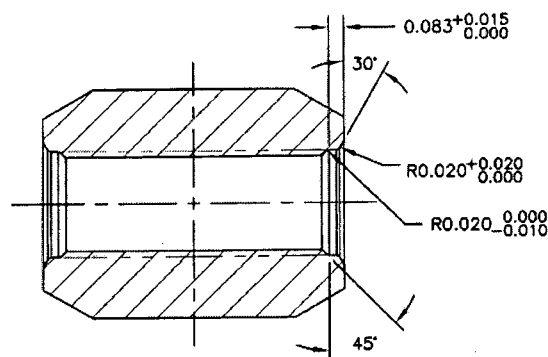
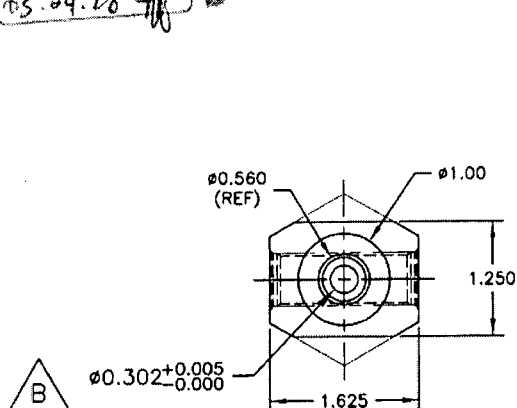
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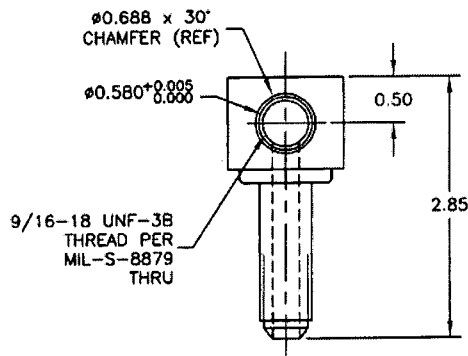
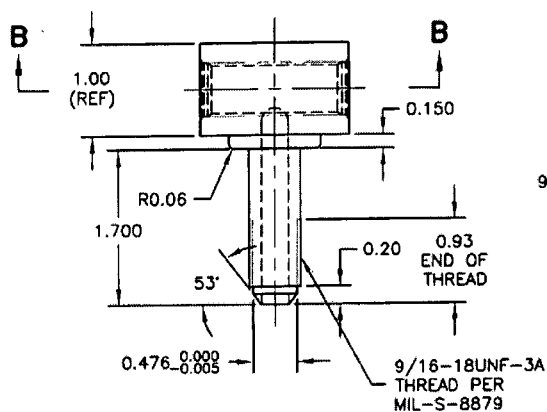


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3299	REV. B SHEET 3 OF 3
DATE 05.04.28	TITLE FITTING		SCALE 1:2

RELEASED
05.04.28



SECTION B-B
SCALE 1:1



D3299-5

D3299-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/B OR QQ-A-225/B) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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TNM

ANODISATION et PEINTURE TNM INC.

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / AS9100 certified
approuvé NADCAP approved

56196

14-Jun-2007

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE**PURCHASE ORDER/**
NO. DE COMMANDE: 00003943

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	10	10	D3299-1 ✓ B30834 ✓	BLUE ANODIZE PER MIL-A-86251 TYPE II CLASS 2 ALL OVER

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL

u

u

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.
Travel cards have been filed and are available for viewing upon request.

Signature/Signed: _____

☐ Directeur de la Qualité / Q.A. Manager ☐
